

Work Order ID 83163

83163

Page 1

April-13-12 10:37:31 AM

Item ID: D4011-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clamp, Short

Start Date: 13/04/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 27/04/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/04/13 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4011	B
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(43)

100	PURCHASING	0.00
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100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

110	QC2- Inspect parts off machine FAI/FAIB	0.00
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110

QC

Memo

0.00

Quality Control

B12-5-20

B12-5-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83163

83163

Page 2

April-13-12 10:37:31 AM

Item ID: D4011-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp, Short
 Start Date: 13/04/2012 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 27/04/2012 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<i>8.2105122</i>		<i>counted</i> <i>(243)</i>	<i>φ</i>		
130 *130* Brake NC Brake NC	Form as per dwg NC BRAKE Memo	0.00 0.00				<i>43</i>			<i>Sp</i> <i>2105/28</i>
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		<i>8.2105128</i>		<i>counted</i> <i>(243)</i>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83163

83163

Page 3

April-13-12 10:37:31 AM

Item ID: D4011-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp, Short
 Start Date: 13/04/2012 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 27/04/2012 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>460</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

42/0/28 (43)

12/5/29 28

MS
12-05-28

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-13-12 10:37:36 AM

Page 1

Work Order ID: 83163

83163

Parent Item: D4011-1

D4011-1

Parent Item Name: Clamp, Short

Start Date: 13/04/2012

Required Date: 27/04/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP RevA: New issue DD verified by:EC
11.05.19 MADE IN HOUSE DD verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA		Purchased	No			100	sf	99.0400	0.063	2.652632	3.		

M304S14GA

**

B12-5-20

304SS sheet .080

Location

Loc Qty

Loc Code

MAT020

99.04

117933

6.6

119276

92.44

119276

43

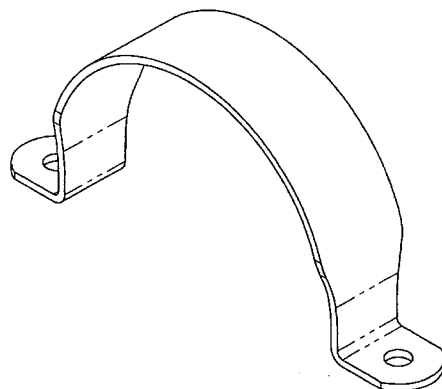
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

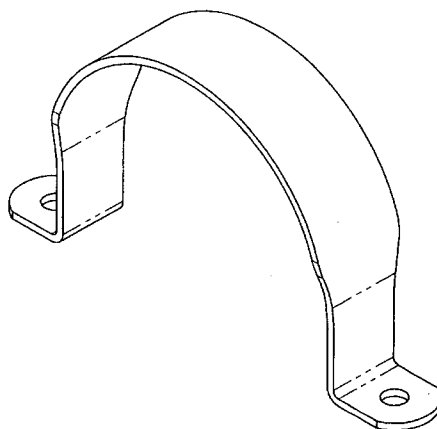
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

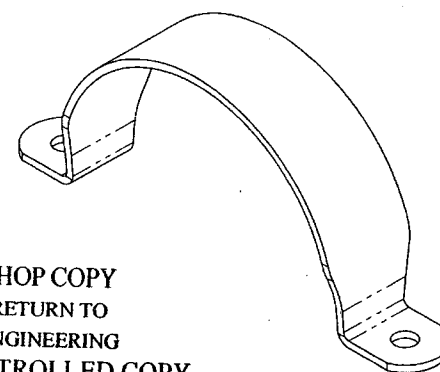
NOTE: Date & initial all entries



D4011-1 CLAMP, SHORT



D4011-3 CLAMP, LONG



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SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 83163 MCT

12/04/13 **D4011-5 CLAMP, SHORT (OEM)**

RELEASED
2009-11-24
mp

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4011-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs EACH

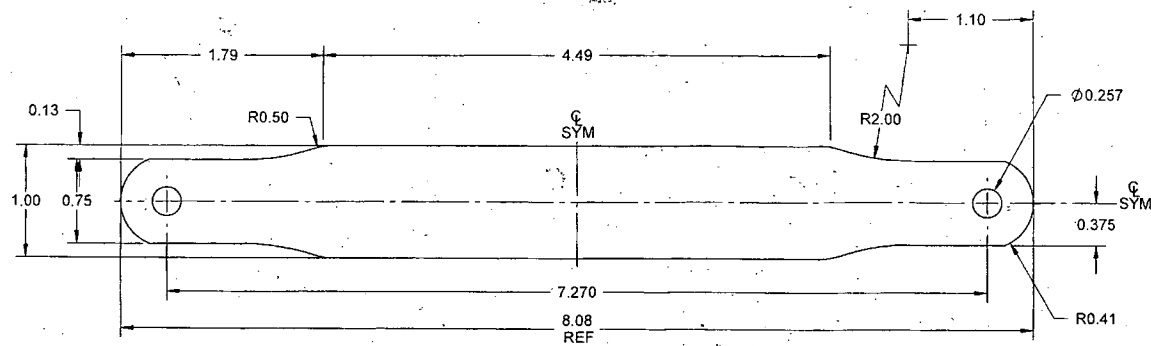
B	SHORTEN HEIGHT OF -1/3 CLAMPS BY 0.125; ADDED -5. REASON: PROVIDE MORE CLEARANCE UPON INSTALLATION ON OEM SKIDTUBES	MB	09.11.11
A	NEW ISSUE	MB	09.10.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>B</i>		
DRAWN	<i>B</i>		
CHECKED	<i>AS</i>		
MFG. APPR.	<i>N</i>		
APPROVED	<i>10</i>		
DE APPR.	<i>#</i>		
DATE	09.11.11		

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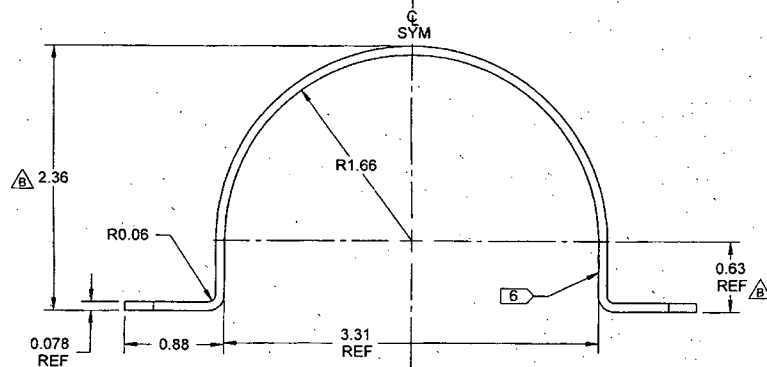
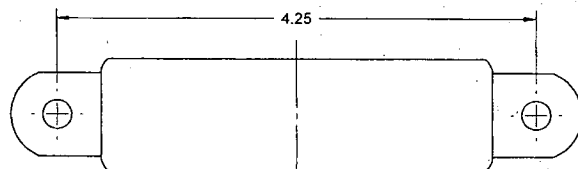
DRAWING NO. **D4011** REV. B
SHEET 1 OF 4
TITLE **CLAMP** SCALE
NTS

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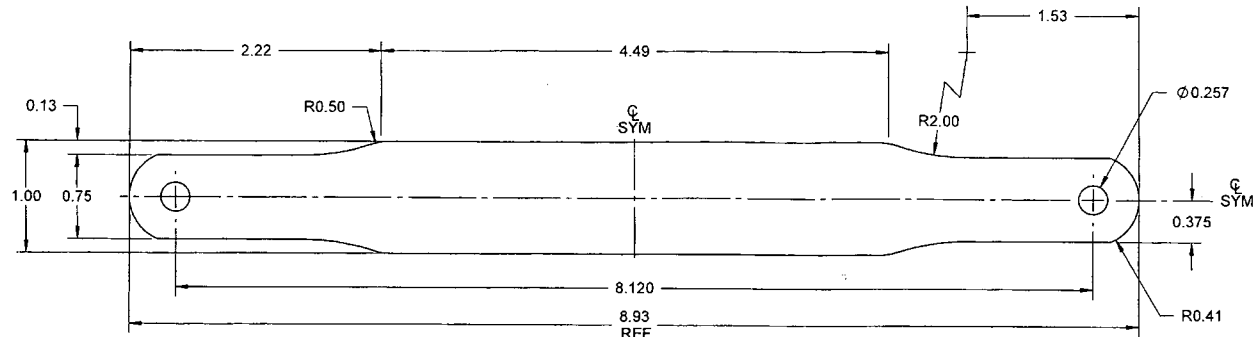
D4011-1F CLAMP, SHORT FLAT PATTERN



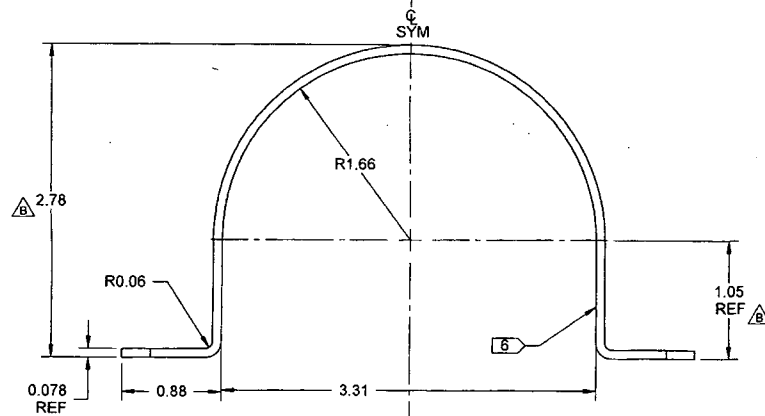
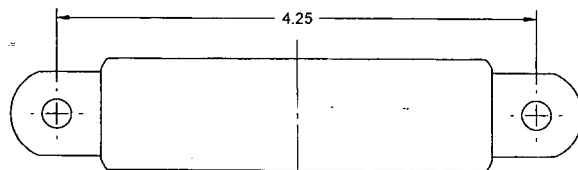
D4011-1 CLAMP, SHORT
(MAKE FROM D4011-1F)

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2009-11-24
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CHECKED	1.5	DRAWING NO. D4011	REV. B
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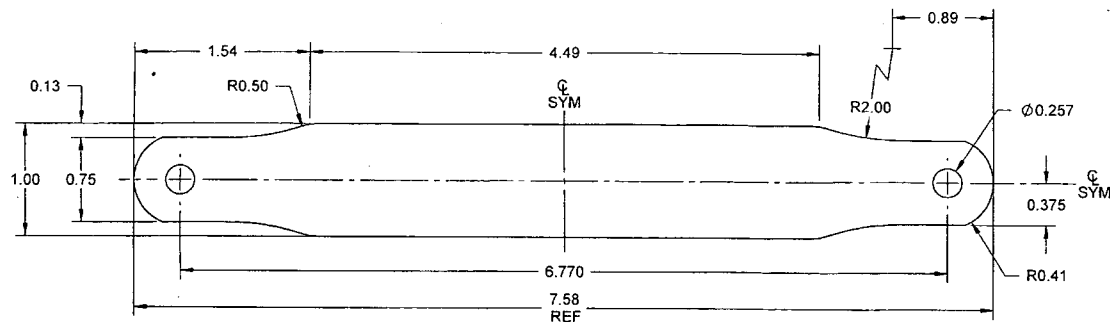
D4011-3F CLAMP FLAT PATTERN, LONG



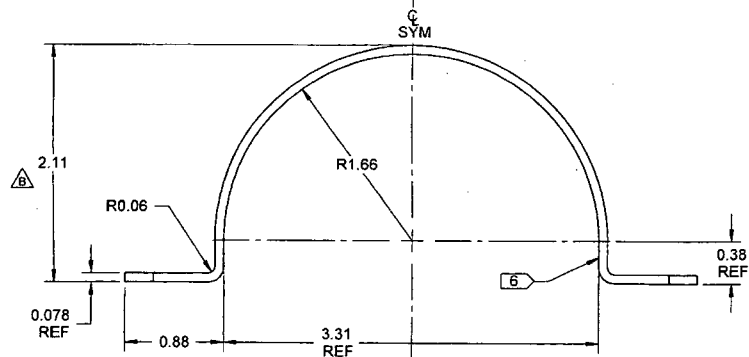
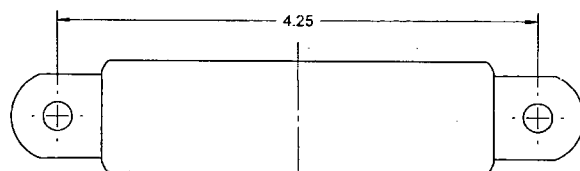
D4011-3 CLAMP, LONG
(MAKE FROM D4011-3F)

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D4011-5F CLAMP, SHORT (OEM) FLAT PATTERN



D4011-5 CLAMP, SHORT (OEM)
(MAKE FROM D4011-5F)

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2009-11-24
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